120

QC4-100% Inspect kits for completeness

0.00

QC

Memo

Memo

Quality Control

Packaging

Packaging

DQA:	Date:	•
-		

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

									QA Closed:	Date	:	
Work Order	·:				DISPOSITION			AGAINST DE	T DEPARTMENT/PROCESS			
Part No. NCR No.					Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstub Machining Small Fa Thermoforming Finishin Large Fab Composit				Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
1101111					Work order opudie	J	Luige Tub	composite [j	3dppiici [_	
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &			
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other												
Process	1											
Supplier	7					C)						
Training	7											
Unapproved	7											
		•			F	AULT CATE	GORY					
Landing	g Gear				General				_			
-	Bending Centre No Cracks	ot Concer	ntric to (o/s	Bend BOM/Route Broken/Damaged	Grain Hardwa Inspecti	ire ion Incomplete		Ovalized Over/Under Part Incorre	⊢	Pressure/Forced Temperature/Cure Weld	
	Crushed/	Crimped.		Г	Burrs	Instruct	ions Incomplete/	'Unclear	Part Lost/Mi	issing	Wrong Stock Pulled	
	Cuffs				Contamination	Mainte	enance		Part Moved	_	_	
	Heat Trea	ıt			Countersink	Mislabe	eled		Positioned V	Vrong		
	Inspection	n Strip in	Tube		Cut Too Short	Misread	t		Power Loss/	Surge	Other	
	Ripples in	Bend			Drill Holes	Offset			-			
	Torque W	/aves in E	xtrusion	ı [Drawing	Out of (Calibration					
Turning Sequence					Finish	Out of 9	Sequence					
Wave/Twist in Tube					Folio	Outside	Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

**1*4*0*

Quality Control

October-19-12 12:43:58 PM Item ID: D350-588-011 Accept *N900040100* Setup Start **Revision ID:** Item Name: Aft Door Fwd Hinge Modification *10* **Start Date:** 19/10/2012 **Start Qty: 10.00 Cust Item ID: Required Date:** 16/11/2012 Req'd Qty: 10.00 **Customer:** Reference: Run Approvals: Process Plan: Date: Tooling: Date: Stop Date: QC: SPC (Y/N): Date: ___ Sequence ID/ Operation Set Up/ Reject Tool ID Tool # Plan Reject Accept **Work Center ID** Description **Run Hours** Code Qty Number Stamp 130 0.00 Packaging *130* Packaging 0.00 Memo Packaging Identify and pack for shipping as per PPP D350-588-011 Location: [22] PPP Rev: 140 QC21- Final Inspection - Work Order Release 0.00

0.00

Memo

Insp.

			DQA:	Date:	
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE	.		
			OA Closed:	Date:	

									QA Closed:	Date): 	
Work Orde	er:				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No					Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstub Machining Small Fa Thermoforming Finishin			4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
IVCK I	10.				Work Order opdate	1	Large Fab	Composite	J	2uppner [_	
Root	Date	Ston	Otv		ption of work order update or Non-conformance	Initial			Sign & Date	Verification	OC Inspector	
Cause Doc/Data	Date	Step	Qty		or Non-comormance	Chief En	g Desc	cription	Date	verification	QC Inspector	
Equip/Tooling	 											
Operator												
Material												
Setup									:			
Other												
Process							1					
Supplier									1			
Training	Ш											
Unapproved						<u> </u>				1		
						AULT CAT	EGORY					
Landi	ng Gear			_	General				7	_	 1	
	Bending				Bend	Grain		<u></u>	Ovalized	L	Pressure/Forced	
		lot Conce	ntric to (o/s _	BOM/Route	Hardy		<u></u>	Over/Under	<u>-</u>	Temperature/Cure	
	Cracks	4		<u> </u>	Broken/Damaged	⊢ '	ction Incomplete	_	Part Incorre		Weld	
	⊢	/Crimped		<u> </u>	Burrs	_	ctions Incomplete/	/Unclear	Part Lost/M	_	Wrong Stock Pulled	
	Cuffs			<u> </u>	Contamination	\vdash	tenance	<u> </u>	Part Moved			
	Heat Tre			<u> </u>	Countersink	Misla			Positioned \		- 1	
		on Strip in	lube	ļ.	Cut Too Short	Misre		<u></u>	Power Loss/	'Surge	Other	
	Ripples			_	Drill Holes	Offset						
Torque Waves in Extrusion				י	Drawing	\vdash	f Calibration					
	⊢ ⊣	Sequence		-	Finish	—	f Sequence				***	
Wave/Twist in Tube				1	Folio	! Outside	de Dimensions				The same of the sa	

October-19-12 12:44:02 PM

Work Order ID: 92021

92021

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

D350-588-011 **Start Date:** 19/10/2012

Start Qty: 10.00

Required Date: 16/11/2012

Page 1

Required Qty: 10.00

Comments:

Parent Item:

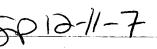
IPP Rev:M04.08.31Added D2690-17KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C1032R7		Purchased	No		· - · · · · ·	120	Each	60.0000		20			+
*ANSORC	1032R7	k							**		8		

_	0 1/1		Location	<u>L</u> c	oc Qty	Loc Code
Sn	NIS 10V		ST348	60		
			116304		10	
4			119449		50	
AN526C832R8	Purchased	No	·	120	Each	187.0000
AIN 52608	₽ ∌₽.8.					**

SMO	107

Location	Loc Qty	Loc Code	
ST345	100		
122814	100		
ST346.	83		
122151	83		
ST347	4		
118926	4		





		DQA:	Date:	
JCD V / N-	MODE ODDED NON CONFORMANCE / LIDDATE			

NCR: Yes / No	WORK ORDER NON-CONFORM	WORK ORDER NON-CONFORMANCE / UPDATE							
		QA Closed:	Date:	**					
Mark Ordan	DISPOSITION	AGAINST DEPARTMENT/PRO	OCESS						
Work Order:		. ==		_					

Work Orde	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Work Orac	• • •					Rework	1 L		Skid-tube	Crosstube	•	Water Jet	Engineering	
Part N	No.					Scrap	1 1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
	•					Use-as-is	1	Therm	noforming	Finishing	Rec/Stor	re/Packaging	Other	
NCR N	١o.					Work Order Update]		Large Fab	Composite		Supplier		
							\perp				I = 27 1 2			
Root			_	_	l	ption of work order update		itial		ction	Sign &	, , , ,		
Cause		Date	Step	Qty		or Non-conformance	Chie	ef Eng	Desc	cription	Date	Verification	QC Inspector	
Doc/Data	\Box										ļ			
Equip/Tooling	-													
Operator	\vdash									•				
Material														
Setup	\dashv													
Other	\dashv													
Process														
Supplier Training														
Unapproved		:												
опарртотса	ш	.		1	l	F	AULT	CATE	GORY		J	· · · —		
Landi	ng (Gear				General		-				<i>i</i>		
	Ŏ	Bending				Bend		Grain			Ovalized	Γ	Pressure/Forced	
		Centre No	ot Concer	ntric to	o/s	BOM/Route	H,	Hardwa	re		Over/Under	tolerance	Temperature/Cure	
		Cracks				Broken/Damaged		nspecti	on Incomplete		Part Incorre	ct	Weld	
		Crushed/0	Crimped.			Burrs	\Box	nstruct	ions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled	
		Cuffs				Contamination		Mainte	nance		Part Moved		·	
		Heat Trea	t			Countersink		Mislabe	led		Positioned \	N rong		
		Inspection	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss/	'Surge	Other	
		Ripples in	Bend			Drill Holes		Offset						
		Torque W	aves in E	xtrusio	n 🗌	Drawing		Out of (Calibration					
		Turning S	equence			Finish		Out of S	Sequence					
		Wave/Tw	ist in Tuk	oe e		Folio	\Box	Outside	Dimensions					

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October-19-12 12:44:02 PM

-Work Order ID: 92021

Parent Item:

AN526C832R9

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

92021

D350-588-011

Start Date: 19/10/2012

Required Date: 16/11/2012

Required Qty: 10.00

Start Qty: 10.00 445.0000 80

Screw

<u>Location</u>	Loc	<u>: Qty</u>	Loc Code	
ST345		400		
122814		400		20
ST346		36		G
120181		21		
121556		4		
122151		11		
ST347		9		
118983		9		
	120	Each	0.0000	4 40

Each

Each

AN960JD10

NAS1149D0363J Purchased

Purchased

Washer ÁN960JD8

Hinge Bracket

NAS1149DN832 Purchased

No

No

No

No

120 0.0000 Each

120

**

Washer D2143

Manufactured

24.0000 **

Locatio	<u>n</u>	Loc Qty	Loc Code
ST		-38	
ST004		19	
	82335	19	
ST005		5	
	76100	5	
ST198		38	



			DQA:	Date:
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE		

			_			, who are				QA Closed:	Date:	
Work Orde	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS			·	
Part N	No					Rework Scrap Use-as-is Work Order Update	The	Machining Small Fab Prod. Eng. Coor. Qual			Engineering Quality Other	
Root					Descri	ption of work order update	Initial	Δ	Action	Sign &		
Cause		Date	Step	Qty	,	or Non-conformance	Chief Er	ng Des	scription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling					i i					ļ		
Operator												
Material												
Setup											·	
Other	Ш											
Process	<u> </u>											
Supplier												
Training												
Unapproved								<u> </u>				
					112		AULT CA	regory				
Landi	ng Gea				_	General	— .			1	F	-
	_	nding	_			Bend	Grai		<u> </u>	Ovalized		Pressure/Forced
			t Concer	itric to	o/s	BOM/Route	Hard		<u> </u>	Over/Under	 	Temperature/Cure
		acks				Broken/Damaged	-	ection Incomplete	 	Part Incorre	 	Weld
	_		Crimped.			Burrs	${f oxed{H}}$	actions Incomplete	e/Unclear —	Part Lost/M	_	Wrong Stock Pulled
	Cu				_	Contamination	\vdash	ntenance		Part Moved		•
	— —	at Treat		- 1		Countersink	\mathbf{H}	beled	<u> </u>	Positioned V		٦٠٠٠
	-	•	Strip in	iupe	<u> </u>	Cut Too Short	Misro		L.	Power Loss/	Surge	Other
		ples in			_	Drill Holes	Offse					<u>-</u> -
	_	•	aves in E	xtruSIO	"	Drawing		of Calibration				
	_	_	e <mark>quence</mark> ist in Tub			Finish	\vdash	of Sequence				
	VV	ave/ i wi	istin iub	E	1	Folio	Outs	ide Dimensions				

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October-19-12 12:44:02 PM

*Work Order ID: 92021

Parent Item:

92021

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Manufactured

Manufactured

No

D350-588-011

Start Date: 19/10/2012

Required Date: 16/11/2012

Start Qty: 10.00

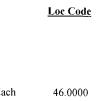
Required Qty: 10.00



SMS	10>

Location	<u>Lo</u>	c Qty
ST005		26
78993		2
84070		12
86879		12
	120	Each

120



26.0000

50.0000

Each

Each



10

P9450	•
Packer Doubler, Hinge	;

D2150

SMP	104
-----	-----

Manufactured	N

Location	Loc Qty	Loc Code
ST005	46	
82136	6	
8 <u>5513</u>	20	
86883	20	





SmB	10)
	• •

Location	Loc Qty	Loc Code
ST005	50	
82137,	10	
85514	20	
86831	20	



DQA:	Date:	

WORK ORDER NON-CONFORMANCE / UPDATE

NCR: Yes / No QA Closed: Date: DISPOSITION **AGAINST DEPARTMENT/PROCESS** Work Order: Engineering Rework Skid-tube Crosstube Water Jet Small Fab Prod. Eng. Coor. Quality Part No. Scrap Machining Finishing Rec/Store/Packaging Thermoforming Other Use-as-is NCR No. Work Order Update Large Fab Composite Supplier Description of work order update Initial Action Sign & Root Chief Eng Description Verification or Non-conformance Date QC Inspector Date Step Qty Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Pressure/Forced Bend Grain Ovalized Bending BOM/Route Temperature/Cure Centre Not Concentric to O/S Over/Under tolerance Hardware Cracks Broken/Damaged Part Incorrect Weld Inspection Incomplete Instructions Incomplete/Unclear Crushed/Crimped. Burrs Part Lost/Missing Wrong Stock Pulled Cuffs Maintenance Contamination Part Moved **Heat Treat** Countersink Mislabeled Positioned Wrong Other Inspection Strip in Tube **Cut Too Short** Misread Power Loss/Surge **Drill Holes** Offset Ripples in Bend **Torque Waves in Extrusion** Drawing Out of Calibration **Turning Sequence** Finish Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio



October-19-12 12:44:02 PM

Work Order ID: 92021

D350-588-011

92021

D350-588-011

Parent Item:

Parent'Item Name: Aft Door Fwd Hinge Modification

Start Date: 19/10/2012 **Start Qty: 10.00**

D2153

D2154

.

Manufactured

No

120

Each

25.0000

10 **

Required Date: 16/11/2012

Required Qty: 10.00

5ms 20y

Manufactured No Location Loc Qty FG 5 85865 5 ST272 20 78369 85865 19 120 Each

Loc Code

55.0000

WX

D2237

Manufactured No Location Loc Qty ST006 55 82333 55 120 Each

Loc Code

Location Loc Oty ST007 57 66139 1 85476 12 86643 24 89925 20 Loc Code

				QA:	Date:	
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE			

				· ·					QA Closed:	Date	2:
Work Order	r.				DISPOSITION			AGAINST DE	PARTMENT	PROCESS	·
Part No	o				Rework Scrap Use-as-is Work Order Update	- I	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training											
Unapproved		<u> </u>				AULT CATE	GORY				<u> </u>
Landin	g Geor			····	General	AULI CAIL	JONI				
	Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs				Bend BOM/Route Broken/Damaged Burrs Contamination	Inspect Instruc Mainte	Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance			tolerance ct issing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
.	Heat Trea				Countersink	Mislab			Positioned \		
-	Inspectio		Tube		Cut Too Short	Misrea	d	L.	Power Loss/	'Surge	Other
-	Ripples ir			<u> </u>	Drill Holes	Offset	- 111				
-	Torque V			^ո	Drawing	 	Calibration				
-	Turning S	-			Finish	\vdash	Sequence				
Wave/Twist in Tube					Folio	I (Outside	e Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

October-19-12 12:44:02 PM

Work Order ID: 92021

92021

Manufactured

Manufactured

Manufactured

Parent Item:

D2461

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

D350-588-011

Start Date: 19/10/2012

Required Date: 16/11/2012

Start Qty: 10.00

Required Qty: 10.00

76.31579

**

cut 1 X 87.00" D2463

cut 1 X 87.00" D2583

Location Loc Qty ST402 146.276684 39782 6.5 55054 63880 14.8237 73644 120.952984 ST402A 442 85225 442

No

No

120

120

759.2221

588.2767

Loc Code

**

76.31579





Location Loc Qty Loc Code ST402 500 90297 500 ST404 259.22207 72232 15.38 79478 0.43737 83542 243.4047

120

36.0000

Loc Code

Each



20

**



Location ST012

> 85427 87625

36 15 21

Loc Qty

Shop Packet Print

DQA:Date:	DQA:		Date:			
-----------	------	--	-------	--	--	--

ICR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

										QA Closed: Date:		
Work Orde	r •				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N					Rework Scrap		ľ	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N	o	:		-	Use-as-is Work Order Update	<u> </u>		Large Fab	Composite	Nec/3ioi	Supplier	
Root				Descri	ption of work order update	Init	Initial Action			Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup												
Other						1						
Process												
Supplier						1					•	·
Training								1				
Unapproved		1				1						
					F	AULT (CATE	GORY				
Landin	ng Gear				General					-	_	_
	Bending				Bend	\vdash	rain			Ovalized	_	Pressure/Forced
	Centre N	ot Conce	ntric to (o/s	BOM/Route	\vdash	ardwa			Over/Under	. -	Temperature/Cure
ļ	Cracks		•	_	Broken/Damaged	-	•	ion Incomplete	<u> </u>	Part Incorre	. –	Weld
1	Crushed/	Crimped		<u> </u>	Burrs			ions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
Į	Cuffs				Contamination			enance	<u> </u>	Part Moved		
1	Heat Trea				Countersink		lislabe			Positioned V	_	· · · · · ·
	Inspectio		Tube		Cut Too Short	-	lisread	d		Power Loss/	Surge	Other
1	Ripples ir			<u> </u> _	Drill Holes		ffset				· · · · · · · · · · · · · · · · · · ·	
Ļ	Torque W			ո _	Drawing			Calibration				
	Turning S				Finish	$\boldsymbol{\vdash}$		Sequence				
1	Wave/Tw	vist in Tul	oe e	-	Folio	Outside Dimensions						

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

October-19-12 12:44:02 PM

Work Order ID: 92021

Parent Item:

D2585

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

92021

No

D350-588-011

Start Date: 19/10/2012

Required Date: 16/11/2012

Start Qty: 10.00

Required Qty: 10.00

73.0000

20 **

D2586

Manufactured No

Manufactured

Location Loc Qty ST012 37 73297 2 85425 11 86945 24 WA 36 89387 36 120 Each

120

Each

130.0000

Loc Code

D2587

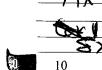
Door Slug, 350 Hinge

Manufactured

Location Loc Qty FG 83893 7 ST198A 100 89150 100 ST203A 23 83893 22 120 Each

24.0000

Loc Code



**

Location Loc Qty ST012 24 74522 78893 3 86830 20

Loc Code

10X

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-O		NFORM	MANCE / UPDATE				
											QA Closed:	Date:	
Work Ord	or.					DISPOSITION			AGA	INST DE	PARTMENT	/PROCESS	
Work Ord	ei.					Rework	ork Skid-tube Crosstube			tube		Water Jet	Engineering
Part	No.					Scrap	}				Pro	d. Eng. Coor.	Quality
						Use-as-is		Therm	noforming Finis	hing	Rec/Sto	re/Packaging	Other
NCR No.						Work Order Update]		Large Fab Comp	osite		Supplier	
Root					Descri	Lption of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data											"		
Equip/Tooling													
Operator													
Material]				1						
Setup	$oxed{oxed}$					'							
Other													
Process													
Supplier	L												
Training													
Unapproved													
							AUL	T CATE	GORY				
Land	ing (1				General	_	7		 -	3	_	7
	Bending					Bend		Grain		<u> </u>	Ovalized	<u> </u>	Pressure/Forced
	Centre Not Concentric to O/S				o/s	BOM/Route	_	Hardwa			Over/Under	h	Temperature/Cure
	<u>_</u>	Cracks				Broken/Damaged	_	4 '	ion Incomplete		Part Incorre		Weld
	<u></u>	Crushed/	Crimped.	-		Burrs		4	ions Incomplete/Unclear	<u> </u>	Part Lost/M		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance	ļ	Part Moved		
	<u></u>	Heat Trea	at			Countersink	_	Mislabe	eled	<u> </u>	Positioned Wrong		7
		Inspection Strip in Tube				Cut Too Short		Misread			Power Loss,	/Surge	Other

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

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October-19-12 12:44:03 PM

Work Order ID: 92021 *92021* Parent Item: D350-588-011 *D350-588-011* Parent Item Name: Aft Door Fwd Hinge Modification Start Date: 19/10/2012 **Required Date: 16/11/2012 Start Qty: 10.00** Required Qty: 10.00 D2589 Manufactured No 196.0000 120 Each 10 ** Keys, Key Chain, 350 Hinge Location Loc Qty Loc Code SMB 104 ST012 196 58194 196 D2690-17 Manufactured No 120 Each 32.0000 Location Loc Qtv Loc Code ST016 32 66510 84069 15 85866 6 86649 87098 6 Manufactured 120 Each 35.0000 10 ** SP12-11-6. Loc Oty Location Loc Code FG 100 82261 ST019 31 75253 82261

85805

18

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE									•		•				
												QA Closed:	Da	te:	
Work Ord	er.					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
Work ord	٠٠٠.					Rework	1		Skid-tube	Crosstube			Water Jet		Engineering
Part	No.					Scrap	1	Machining Small Fab			_	Prod. Eng. Coor.			Quality
	•	· · · · · · · · · · · · · · · · · · ·				Use-as-is		Thermoforming Finishing				Rec/Stor	e/Packaging		Other
NCR 1	NCR No.					Work Order Update			Large Fab	Composite			Supplier		
Root			T		Descri	ption of work order update		Initial	Ac	tion		Sign &			
Cause	,	Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
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Material	Ш														
Setup	Ш														
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Landi		1				General		la :			_	1		$\overline{}$]
	\vdash	Bending				Bend	-	Grain				Ovalized		\vdash	Pressure/Forced
	\vdash	Centre N	ot Concer	ntric to ()/5 -	BOM/Route	\vdash	Hardwa			-	Over/Under		-	Temperature/Cure
	-	Cracks	-· ·			Broken/Damaged	\vdash	⊣ `	on Incomplete		-	Part Incorre		-	Weld
	-	Crushed/	Crimped.		<u> </u>	Burrs	-	-1	ions Incomplete/	Unclear	\vdash	Part Lost/M	•	$ldsymbol{L}$	Wrong Stock Pulled
	Н	Cuffs			<u> </u>	Contamination	\vdash	Mainte			-	Part Moved			
	Н	Heat Trea			<u> </u>	Countersink	-	Mislabe			\vdash	Positioned V	-		1
	\vdash	Inspectio		Tube	<u> </u>	Cut Too Short	\vdash	Misread	t			Power Loss/	'Surge	_	Other
1	Ripples in Bend			1	Drill Holes	1	Offset					=			

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

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Work Order ID: 92021

D350-588-011

92021

No

D350-588-011

Parent Item:

Ď2857-2

D2858-1

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 19/10/2012

Each

120

Start Qty: 10.00

Required Date: 16/11/2012

Required Qty: 10.00

3×89/544 8P

Manufactured

Manufactured

Location Loc Qty FG ST019 27 85806 20 120 Each

Loc Code

31.0000

32.0000

Loc Code

10

**

D2858-2

Manufactured No Location Loc Qty ST019 30 63695 77019 24 120 Each

51.0000

**

Location Loc Qty Loc Code FG 77020 2

ST020

49 77020 82336 23 89263 24

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Shop Packet Print

Page 8

NCR: Y	CR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE													
									4.4		QA Closed:	Date:		
Work Orde	r: _					DISPOSITION	N			AGAINST DE	PARTMENT/	PROCESS	`	
Part N NCR N	_					Rew So Use-a Work Order Upo	erap as-is	Skid-tube Crosstube Machining Small Fal Thermoforming Finishin Large Fab Composite			Rec/Stor	Water Jet d. Eng. Coor. re/Packaging :Supplier	Engineering Quality Other	
Root					Desci	ription of work order up	date	Initial	Act	tion	Sign &	a		
Cause		Date	Step	Qty		or Non-conformance	1	nief Eng	Desc	ription	Date	Verification	QC Inspector	
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	E	Bending				Bend		Grain			Ovalized		Pressure/Forced	
		Centre No	t Concer	ntric to	o/s [BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
,		Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part Incorre	ct	Weld	
		Crushed/C	rimped.			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled	
		Cuffs				Contamination		Mainte	enance		Part Moved			
Ī		Heat Treat	t		Γ	Countersink		Mislabe	eled		Positioned V	Vrong	_	
		nspection	Strip in	Tube	Γ	Cut Too Short		Misread	t		Power Loss/	'Surge	Other	
Ī	F	Ripples in	Bend			Drill Holes		Offset			-			
Ī	T	Torque Wa	aves in E	xtrusio	,	Drawing		Out of (Calibration			·		
Ī	7	Turning Se	equence			Finish		Out of S	Sequence					
Ī	Wave/Twist in Tube					Folio		Outside Dimensions						

DQA:

Date:

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October-19-12 12:44:03 PM

Work Order ID: 92021 *92021* Parent Item: D350-588-011 *D350-588-011* Parent Item Name: Aft Door Fwd Hinge Modification Required Date: 16/11/2012 **Start Date:** 19/10/2012 Required Qty: 10.00 **Start Qty: 10.00** FG-778150-550-ROL Purchased No 120 sf 1.747.500 7781 9oz Glass 50"x125yd Location Loc Qty Loc Code Sms 20% CA 1747.5 123239 1747.5 1- cut 1 squarre ft of glass cloth MS20426AD3-4 Purchased No 120 Each 120 Location Loc Qty Loc Code 333 1641 122452 1641 FG 8000 123352 8000 ST316 135 104374 135 ST334 10656 123021 2656 20x 123164 8000 MS20470AD4-5 Purchased No 120 Each 1,663.000 180 ** Rivet, Universal Head Location Loc Qty Loc Code 334 1370 122452 1370

293

103

190

ST319

118405

NCR:	Yes ,	/ No				WORK ORDER NON-O	CONF	ORN	AANCE / UPDATE					
											QA Closed:	Date	e:	
Work Orde	er:			•		DISPOSITION			AGAI	NST DE	EPARTMENT/PROCESS			
1 1 1					Rework Scrap Use-as-is Work Order Update		l Therm	Skid-tube Crosst Machining Small noforming Finish Large Fab Compo	Fab	4	Water Jet d. Eng. Coor. re/Packaging Supplier	:	Engineering Quality Other	
Root					Descri	ption of work order update	Init	tial	Action		Sign &		•	
Cause		Date	Step	Qty	(or Non-conformance	Chie	f Eng	Description		Date	Verification		QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
					· · · · · · · · · · · · · · · · · · ·		AULT	CATE	GORY					
Landi					_	General					7	Г	-	
	Bend				4	\vdash	rain		-	Ovalized		_	Pressure/Forced	
	Centre Not Concentric to O/S BO			BOM/Route	H	Hardware			Over/Under tolerance		~6	Temperature/Cure		

Inspection Incomplete

Maintenance

Out of Calibration.

Outside Dimensions

Out of Sequence

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Broken/Damaged

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Burrs

DQA:

Part Incorrect

Part Lost/Missing Part Moved

Positioned Wrong

Power Loss/Surge

Date:

Weld

Other

Wrong Stock Pulled

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

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October-19-12 12:44:03 PM

Work Order ID: 92021

Parent Item:

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

92021

D350-588-011

Start Date: 19/10/2012

Required Date: 16/11/2012

Start Qty: 10.00

Required Qty: 10.00

MS21042L08

Purchased

Purchased

No

No

120

Each

Locatio	<u>n</u>	<u>Lo</u>	e Oty
315			47
	122452		47
ST315			500
	122814		500
ST317			687
	122141		687
		120	Eacl

Loc Code

3,340.000

MS21042L3 *MS21042134

<u>Locatio</u>	<u>n</u>	Loc Qty	Loc Code
316		651	
	122452	651	
ST300		338	
	117885	32	
	119017	168	
	119075	138	
ST314		1831	
	123265	1831	
ST317		520	

520

			DQA:	Date:	~ 4
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

									QA Closed:	Date:			
Work Order	r:				DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Rework]	Skid-tube	Crosstube	Water Jet		Engineering		
Part No	0.				Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
					Use-as-is	Theri	rmoforming Finishing		Rec/Store/Packaging		Other		
NCR No.					Work Order Update]	Large Fab	Composite	÷	Supplier			
Root	ot Descri			Descri	ption of work order update	corder update Initial Action			Sign &				
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Des	cription	Date	Verification	QC Inspector		
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Operator						i :							
Material													
Setup	_		1										
Other	_												
Process													
Supplier							1						
Training -													
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Landing	g Gear				General				-	· ·	_		
	Bending				Bend	Grain			Ovalized		Pressure/Forced		
	Centre No	ot Conce	ntric to C	D/S	BOM/Route	Hardw	are	L.	Over/Under tolerance		Temperature/Cure		
	Cracks		Broken/Damaged	Inspec	ion Incomplete		Part Incorrect		Weld				
L	Crushed/Crimped.		Burrs	Instruc	uctions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled				
	Cuffs			Contamination	Maint	Maintenance		Part Moved					
	Heat Treat			Countersink	Mislab	eled	<u></u>	Positioned Wrong		_			
	Inspection	n Strip in	Tube		Cut Too Short	Misrea	ıd		Power Loss/	'Surge	Other		
	Ripples in	Bend			Drill Holes	Offset							
	Torque W	aves in E	xtrusion	ı [Drawing	Out of	Calibration						
	Turning S	equence			Finish	Out of	Sequence						
	Wave/Twist in Tube				Folio	Outsid	Outside Dimensions						

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

October-19-12 12:44:03 PM

Work Order ID: 92021

Parent Item:

MS27039-08-11

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Purchased

Purchased

92021

No

No

D350-588-011

Start Date: 19/10/2012

Required Date: 16/11/2012

Start Qty 10.00

Required Qty: 10.00

646.0000

20

\$27039<u>-08</u>5116

Location	<u>on</u>	Loc Qty					
309			100				
	122441		100				
ST292			46				
	120833		46				
ST307			500				
	123352		500				
		120	Each				

120

Each

1

100

100

Loc Code

Loc Code

147.0000

Location	Loc Qty
308	44
122459	44
ST291	3
118574	. 2

119736

123352

ST305



NCR:	/es	/ No				WORK ORDER NON-O	COI	VFORM	MANCE / UP	DATE			· · · · · · · · · · · · · · · · · · ·		
												QA Closed:	Da	te:	
Work Order:						DISPOSITION	AGAINST DEPARTMENT/PROCESS								
VVOIK OIGE	٠, .					Rework	1 - [Skid-tube	Crosstube			Water Jet		Engineering
Part N	lo.					Scrap	1		Machining	Small Fab		Prod. Eng. Coor.			Quality
	•					Use-as-is	1		noforming	~ 		re/Packaging		Other	
NCR I	۷o.	<u></u>				Work Order Update]		Large Fab	Composite			Supplier		
				r ·	·							T			
Root						ption of work order update	1	nitial		tion		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desci	ription		Date	Verificatio	n_	QC Inspector
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Landi	ng (ear				General	_	-				-			-
		Bending				Bend		Grain .			Ovalized	•		Pressure/Forced	
		Centre No	ot Concei	ntric to	o/s	BOM/Route		Hardware				Over/Under	tolerance	<u>L</u>	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete			Part Incorre	ct		Weld
		Crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/	Unclear		Part Lost/M	issing		Wrong Stock Pulled
		Cuffs				Contamination		Maintenance				Part Moved			_
		Heat Trea	t		Γ	Countersink		Mislabe	led			Positioned \	V rong		
	Inspection Strip in Tube			Tube		Cut Too Short		Misread				Power Loss/	'Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Wayes in Extrusion

Drill Holes

Drawing

Finish

Folio

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ICA-D350-588

ICA Page 33 (34 blank) of 34

52.3 WEIGHT AND BALANCE

Installation	Weight	LAT	ERAL	LONGITUDINAL		
		Arm	Moment	Arm	Moment	
D350-588-011 Aft Door Fwd Hinge Modification Kit	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb	
	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg	
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb	
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg	

^{*} D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

Revision: 0

588 -041	588 -011	Part Number	Description
Х	***	D350-588-041	AFT DOOR ASSEMBLY
	Х	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	<u></u>	D2143	HINGE DOUBLER
1	_acl=_	D2144	#HINGE:DOUBLER
2	2	D2150	-HINGE PACKER
2	2=	D2151	-HINGE DOUBLER
1	1	■ D2453-3315-10	GAS:SPRING-ASSY.
1	<u> </u>	D2:154	-STUD-BRACKET->
2	[= 2=	D2237	STRIKER PLATE
1		D2445	DOOR
1	C1	D2461=0870	=NEOPRENE:D:SEAL
1	43	D2463-0870	-½"FOAM:SEAL
	C2=	D2583	LATCH:BRACKET
2	-2=	D2585	-LATCH CLAMP
2	- 2	D2586	LATCH
		D2587	*PEUG
1	c-1	D2589	KEYS, KEY-CHAIN
2		D2621	LATCH PLATE
1	<i>6</i> 1==	D2690_17	≠€ABLE;=DΘΘR;STOP
1		D2857-1	FLOWER:HINGE:BRACKET
1	*p	———D2857=2====	EUPPER:HINGE:BRACKET
1	1	D2858-1	*LOWER HINGE BRACKET
1		D2858-2	-UPPER-HINGE-BRACKET
8	-8 ==	AN526C832R8	=SCREW=(or'AN526-832R8)
8	~ 8=	AN526C832R9	SCREW_(or-AN526-832R9)
2	=2==	AN526G1032R7	=SGREW_(or-AN526=1032R7)"
24	=24 =	AN960JD8====	=WASHER
4	C4 ==	AN960JD10	=WASHER_
12	~ 12 =	MS20426AD3-4	-RIVET
18	6 18	MS20470AD4-5	*RIVET
18	<18≦	MS21042E08	=NUT-(or:MS21042-08)_
4	4	MS21042L3	=NUT==(or MS21042-3)
2	4-2==	MS27039-1-15	SCREW
2	<u>~2</u> ==	MS27039-0811	-SCREW
1		N/A	=1-SQUARE-ft-OF-9:oz-GLASS-CLOTH_(S-CLASS)-

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